

Date: Monday, 6/5/2006 11:01:12 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE	
Job Number	: 27410		Part Number	: D29321	
Estimate Number	: 10831		Drawing Number	: D2932 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/5/2006 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/30/2006	
Previous Run	: 27147		Qty:	6	
Written By	: <u>JK</u> 06.06.05		Um:	Each	
Checked & Approved By					
Comment	: Est: B 00.06.26 New DWG rev, (mpp 2069) EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length Batch No: <u>B25347</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 06/08/08

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 11:01:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 27410

Part Number: D29321

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	POWDER COATING	POWDER COATING
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	PACKAGING 1	PACKAGING RESOURCE #1
10.0	DC	DOCUMENT CONTROL

Comment: SECOND CHECK *ML 06/08/19 6*

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1 *AM 06-08-22 6*

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 *DL 06/08/23 6*

Comment: INSPECT POWDER COAT *SL 06/08/25 6*

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *ST 474* *SL 06/08/25 6*

Comment: DOCUMENT CONTROL
Inspection Level 21 *DL 06/08/28 6*

Job Completion



U 06/08/27

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27410
Description: 206 Saddle, Outboard, Left side		Part Number:	D2932-1
Inspection Dwg: D2932 Rev. B			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.122	.121	.121		
B	0.100	0.140		.120	.122	.120	.119		
C	0.100	0.140		.122	.119	.122	.122		
D	0.210	0.230		.220	.211	.218	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.501	2.500		
K	0.257	0.262	DT8683	.259	.259	.259	.259		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		.239	.238	.238	.238		
N	0.100	0.140		.113	.118	.118	.117		
O	0.540	0.560		.546	.549	.550	.550		
P	0.490	0.510		.495	.496	.499	.500		
Q	3.715	3.725		3.719	3.719	3.719	3.719		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.248	.248	.247	.248		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.319	.319	.319	.319		
X	1.125	1.145		1.132	1.132	1.132	1.131		
Y	1.565	1.585		1.571	1.571	1.571	1.570		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD	/	JL	Audited by:	JK	/	JK
Date:	06/08/17	/	06/08/19	Date:	06/08/19		

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	JK

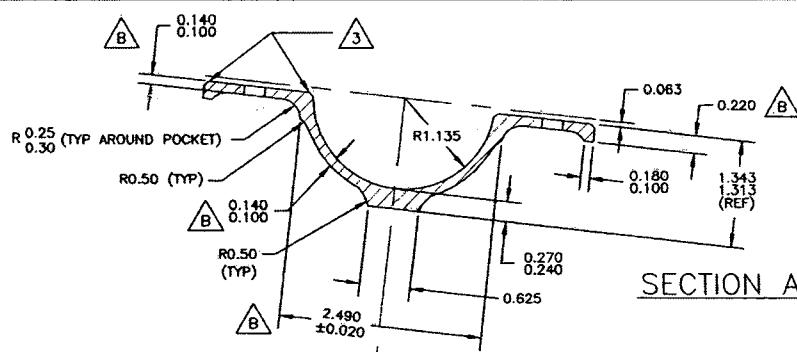
DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Outboard, Left side		Part Number:	D2932-1
Inspection Dwg: D2932 Rev. B			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

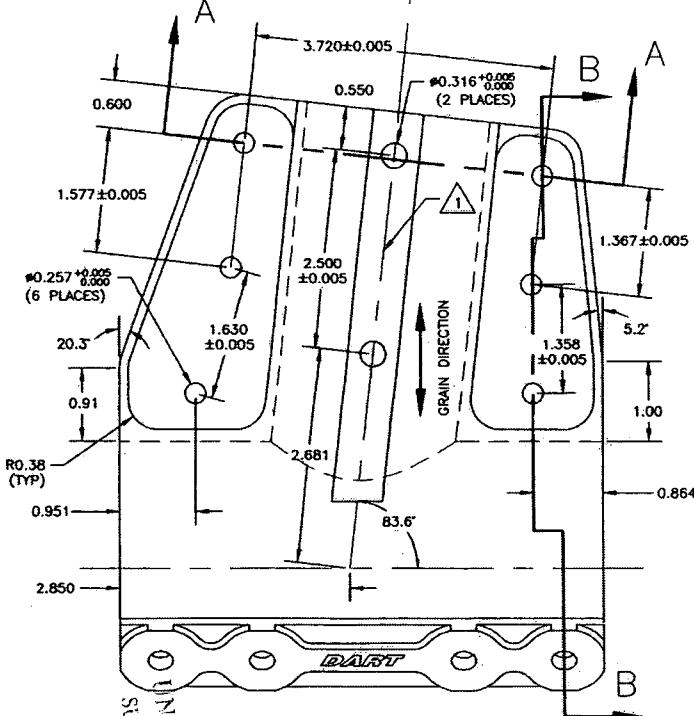
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.121				
B	0.100	0.140		.121	.121				
C	0.100	0.140		.122	.120				
D	0.210	0.230		.217	.217				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.514	.514				
I	1.572	1.582		1.576	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262	DT8683	.259	.259				
L	0.312	0.317	DT8686	.314	.314				
M	0.235	0.240		.239	.238				
N	0.100	0.140		.115	.117				
O	0.540	0.560		.549	.550				
P	0.490	0.510		.500	.501				
Q	3.715	3.725		3.720	3.719				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		.247	.248				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	.319	.319				
X	1.125	1.145		1.131	1.132				
Y	1.565	1.585		1.570	1.571				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L	Audited by:	<i>Onk</i>
Date:	06/08/19	Date:	06/08/19

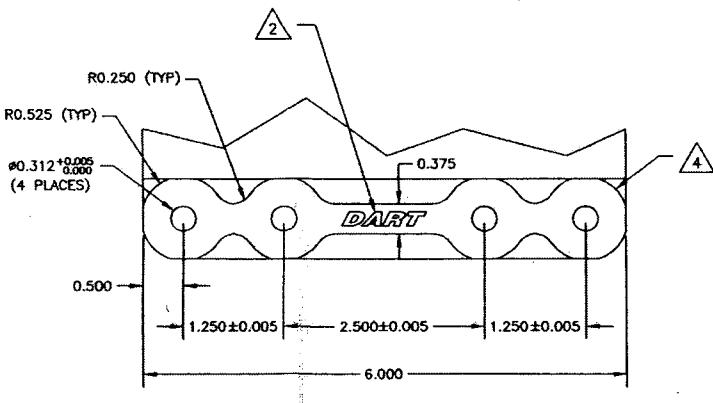
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	



SECTION A-A



SECTION B-B



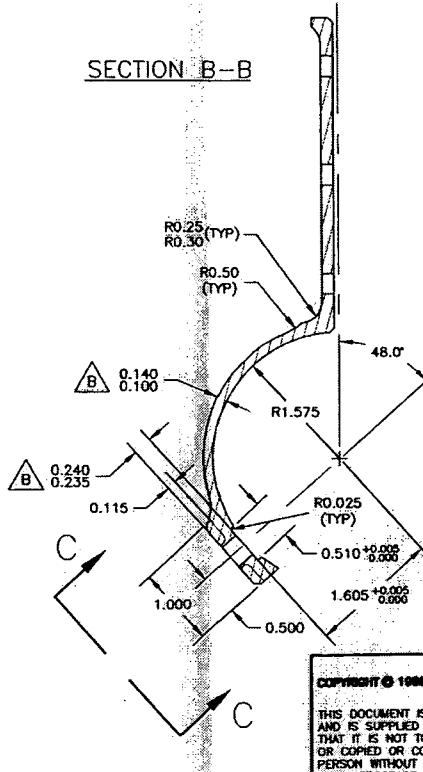
VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (00-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED
(00.05.31)



Copyright © 1998 by DART Aerospace USA, Inc.

This document is private and confidential and is supplied on the express condition that it is not to be used for any purpose or copied or communicated to any other person without written permission from DART Aerospace USA, Inc.

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART Aerospace USA, Inc.
	RF	BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2932
		REV. B
DATE		SHEET 1 OF 1
00.05.29		TITLE SADDLE OUTSIDE
		SCALE

17742
NO. 17742
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING

1707